

Split  
Work Order ID 108593-1

October-23-13 10:20:32 AM

\*108593\*

Page 1

Item ID: D3709-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle

Start Date: 10/23/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/25/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709Dwg Rev: A Prog Rev: A

\*\*\*\*grain direction on a 45 degree \*\*\*\*

2- Deburr by hand only

~~necessary~~

13.10.23

6 0 Jm13-10-23

110

0.00

\*110\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

6 0 Jm13-10-23

110 →

120

0.00

\*120\*

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

DAS  
27  
9-89

13.10.23

6





NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AK Date: 13/11/05

QA Closed: AK Date: 13/10/30

Work Order: <u>108593</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D3709-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-3176</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	<u>13/10/23</u>	<u>100</u>	<u>6</u>	<u>part crack when forming</u> <u>Don't have to be deburr on deburring machine</u> <u>RC. No instructions to avoid Pass in through Debur in mach.</u>	<u>S</u> <u>60202</u> <u>13/10/29</u>	<u>Scrap + destroy</u> <u>replace</u> <u>add specification on w/o</u> <u>606176 S.043</u> <u>M 127006 X6</u> <u>\$2.38</u>	<u>AK</u> <u>13-10-23</u>	<u>DAS</u> <u>27</u> <u>9-88</u> <u>131034</u>	<u>S</u> <u>0204</u> <u>13/10/29</u>
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input checked="" type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other





## Work Order ID 108593

\*108593\*

Page 2

October-23-13 10:20:32 AM

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Stop \*NS2\*

Item Name: Angle

Start Date: 10/23/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/25/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

\*130\*

Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3709

0.00

0.00

2

8/13/10/25

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS  
27  
9-89

B. 10-25

2

150

\*150\*

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

2

7/13-10-25



# Work Order ID 108593

October-23-13 10:20:32 AM

\*108593\*

Page 3

Item ID: D3709-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle

Start Date: 10/23/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 10/25/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

\*160\*

QC

Quality Control

QC3-Inspect Part Finish

Memo

0.00

0.00

Shb  
13.10.25

2

170

\*170\*

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

57190

0.00

0.00

13/10/25 @

DAS  
32  
9-86

180

\*180\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

HA/Rm 13/10/29

13.10.25







# Picklist Print

October-23-13 10:20:37 AM

Page 1 / 1

Work Order ID: 108593

Parent Item: D3709-1

Parent Item Name: Angle

Start Date: 10/23/13

Required Date: 10/25/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-10-31 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063  
6061-T6 .063 Sheet

Purchased

No

sf

573.7905

2

Im 3-10-23

## Location

MAT021

123135

124003

M126075

M127006

## Loc Qty

573.7905

120.2625

72.113

99.415

282

## Loc Code

127006









W/O 108593

RELEASED  
9/24/94

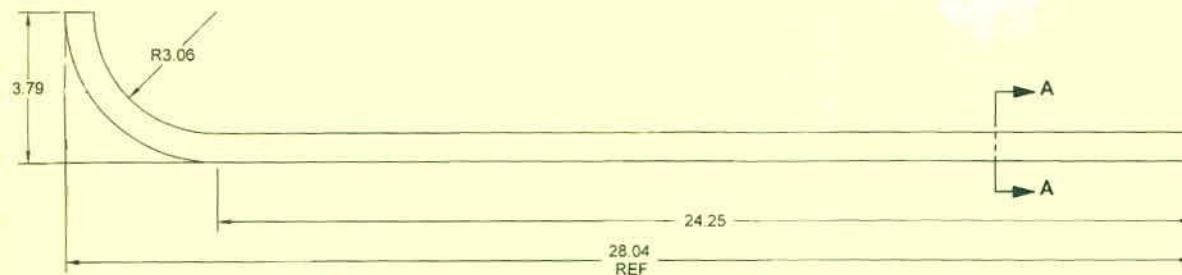
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs  
D3709-3 = 0.16 lbs

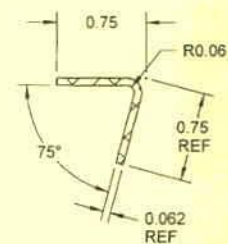
A	NEW ISSUE		MB	08.05.02
REV.		DESCRIPTION	BY	DATE
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DRAWN	1	HAWKESBURY, ONTARIO, CANADA		
CHECKED	1	DRAWING NO.		REV. A
MFG APPR.	1	D3709		SHEET 1 OF 3
APPROVED	1	TITLE		SCALE
DE APPR.	1	ANGLE		NTS
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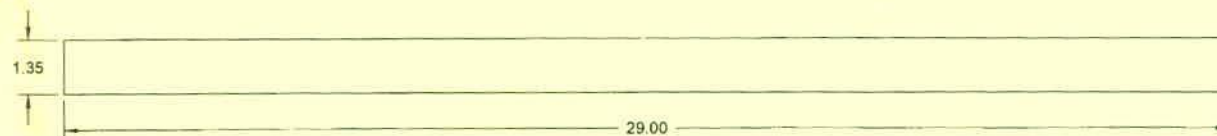




**D3709-1 ANGLE**  
(MAKE FROM D3709-1F)



**SECTION A-A**  
SCALE 2X

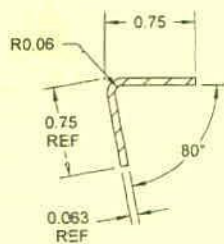


**D3709-1F ANGLE FLAT PATTERN**

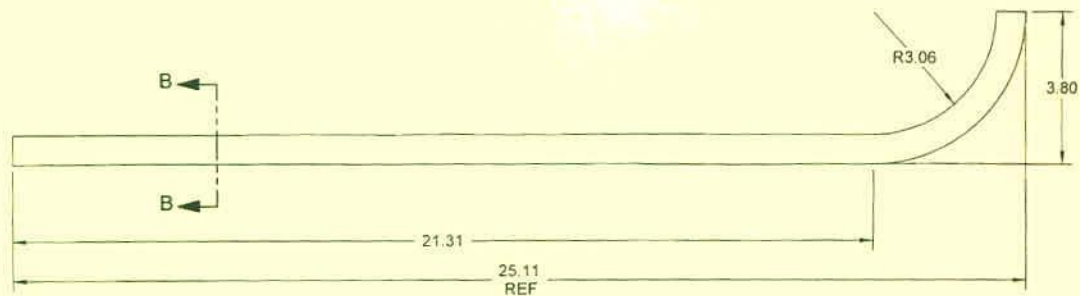
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09/04/09

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DE APPR.		ANGLE	NTS
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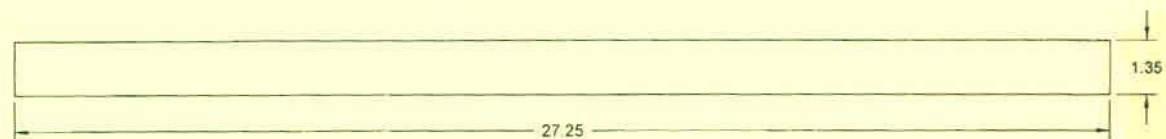




**SECTION B-B**  
SCALE 2X



**D3709-3 ANGLE**  
(MAKE FROM D3709-3F)



**D3709-3F ANGLE FLAT PATTERN**

**RELEASED**  
07/04/08

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